

Work Order ID 82116

82116

Page 1

March-23-12 10:43:15 AM

Item ID: D3458-3 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Step Mounting Plate
 Start Date: 22/03/2012 Start Qty: 24.00 ***24*** Cust Item ID:
 Required Date: 05/04/2012 Req'd Qty: 24.00 ***24*** Customer:
 Reference:

Approvals: Process Plan: MLJ Date: 12/03/23 Tooling: _____ Date: _____
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____
 Run Start ***NR1***
 Stop ***NR2***

| Sequence ID/ Work Center ID | Operation Description | Set Up/ Run Hours | Tool ID | Tool # | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|--------------------------------|--------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|
| Draw Nbr | Revision Nbr | | | | | | | | |
| D3458 | Rev A | | | | | | | | |

| | | | | | | | | | |
|-------------------|---|------|--|--|--|------|--|--|--------------|
| 100 | FLOW WATER JET | 0.00 | | | | (24) | | | SM / 12-4-16 |
| *100* | | | | | | | | | |
| Waterjet | Memo | 0.00 | | | | | | | |
| FLOW CNC Waterjet | 1-Cut as per Dwg D3458 | | | | | | | | |
| 6061 BAR | Dwg Rev: <u>A</u> | | | | | | | | |
| 1.87 x 4.00 | Prog Rev: <u>A</u> | | | | | | | | |
| | 2-Deburr if necessary | | | | | | | | |
| 110 | QC2- Inspect parts off machine FAI/FAIB | 0.00 | | | | (24) | | | SM / 12-4-16 |
| *110* | | | | | | | | | |
| QC | Memo | 0.00 | | | | | | | |
| Quality Control | | | | | | | | | |
| 120 | QC8- Inspect parts - second check | 0.00 | | | | | | | |
| *120* | | | | | | | | | |
| QC | Memo | 0.00 | | | | | | | |
| Quality Control | | | | | | | | | |

counted
(24)

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|--------------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
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NOTE: Date & initial all entries

Work Order ID 82116

March-23-12 10:43:15 AM

82116

Page 2

Item ID: D3458-3 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Step Mounting Plate
 Start Date: 22/03/2012 Start Qty: 24.00 ***24*** Cust Item ID:
 Required Date: 05/04/2012 Req'd Qty: 24.00 ***24*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

| Sequence ID/ Work Center ID | Operation Description | Set Up/ Run Hours | Tool ID | Tool # | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|----------------------------------|--|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|
| 130 *130* Small Fab | Small Fab | 0.00 | | | | | | | |
| Small Fab | Memo | 0.00 | | | | | | | |
| Small Fab | Deburr parts per dwg D3458 | | | | | | | | |
| 140 *140* QC | QC5- Inspect part completeness to step on W/O | 0.00 | | | | | | | |
| Quality Control | Memo | 0.00 | | | | | | | |
| 150 *150* Packaging | Identify as per dwg & Stock Location: <u>W/A</u> | 0.00 | | | | | | | |
| Packaging | Memo | 0.00 | | | | | | | |
| Packaging | *** STOCK IN STEP CELL*** | | | | | | | | |

24 ϕ 12.04.16

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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NOTE: Date & initial all entries

Work Order ID 82116***82116***

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March-23-12 10:43:15 AM

Item ID: D3458-3

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Step Mounting Plate

Start Date: 22/03/2012 Start Qty: 24.00

24

Cust Item ID:

Required Date: 05/04/2012 Req'd Qty: 24.00

24

Customer:

Reference:

Approvals:

Process Plan: _____

Date: _____

Tooling: _____

Date: _____

Run Start ***NR1***

QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

160

QC21- Final Inspection - Work Order Release

0.00

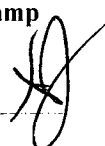
160

QC

Memo

0.00

Quality Control

12/4/17 MF
12-04-17

| W/O: | | WORK ORDER CHANGES | | | | | |
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NOTE: Date & initial all entries

Picklist Print

March-23-12 10:43:20 AM

Page 1

Work Order ID: 82116

82116

Parent Item: D3458-3

D3458-3

Parent Item Name: Step Mounting Plate

Start Date: 22/03/2012

Required Date: 05/04/2012

Start Qty: 24.00

Required Qty: 24.00

Comments: IPP REV. A 05.12.13 NEW ISSUE EC

| Component Item ID/ Item Name | Replacement Item ID | Mfg/ Purch | Bin Item | Primary Location | Last Location | Route Seq ID | Unit of Measure | Qty on Hand | Qty per Kit | Total Qty | Qty Issued | Date Issued | Status |
|---------------------------------|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|----------------|-------------|--------------|---------------|----------------|--------|
| M6061T6B0.187X04.00 0 | | Purchased | No | | | 100 | f | 27.8200 | 0.0427 | 1.078737 | | | |

M6061T6B0 187X04 000

**

6061-T6 Bar .187 x 4.00

Location

Loc Qty

Loc Code

MAT001

27.82

119581

27.82

119581

(24)

M/L/SM
12-4-16

| W/O: | | WORK ORDER CHANGES | | | | | |
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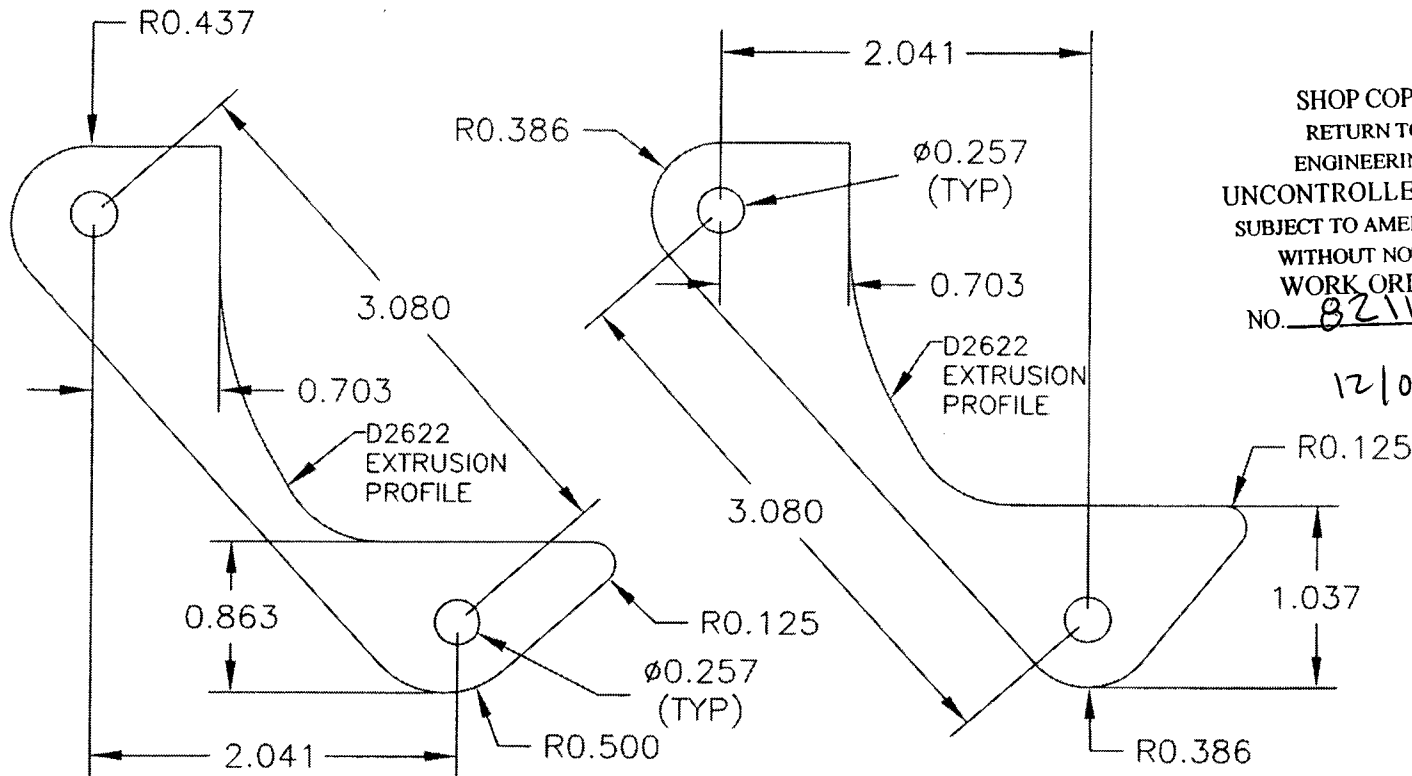
NOTE: Date & initial all entries



SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 82116 *MLJ*

12/03/23

| DESIGN | DRAWN BY | DART AEROSPACE USA, INC. | REV. A |
|---------------|----------|---------------------------|--------------|
| 04 | 04 | PORT HADLOCK, WA | |
| CHECKED | APPROVED | DRAWING NO. D3458 | SHEET 1 OF 1 |
| DATE 05.09.23 | | TITLE STEP MOUNTING PLATE | SCALE 1:1 |
| A | 05.09.23 | NEW ISSUE | |



D3458-1 STEP MOUNTING PLATE

D3458-3 STEP MOUNTING PLATE

D3458-1/-3 STEP MOUNTING PLATE

- 1) MATERIAL: ALUMINUM 6061-T6 (QQ-A-250/11) 0.188 THICK
(REF DART SPEC. M6061T6S.188)
- 2) FINISH: NONE
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

RELEASED
05-11-14

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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NOTE: Date & initial all entries